

Work Order ID 48588A



Page 1

July 1, 2009 8:24:35 AM

Item ID: D3821-1KIV

Accept



Setup Start



Revision ID: B

Stop



Item Name: Panel w/o Rotor Brake-Ivory

Start Date: 07/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

M109708 BB 09/07/01 (X1)

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA023 using tool DT9053
Dwg Rev: AB
Folio Rev: A

BB 09/07/01 (X1)

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Page 2

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Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Memo

0.00



HandThermo

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

0.00

BB 07/07/08 (X1)

OK 09/07/08 (X1)

BB 07/07/08 (X1)

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Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00

BB 09/02/08 (X1)



QC

Memo

0.00

Quality Control

Complete FAI document

160

QC5- Inspect part completeness to step on W/O

0.00

=> 809/07/08 (X)



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00

9/7/9 (X) SY



Packaging

Memo

0.00

Packaging

Work Order ID 48588A

Page 4

July 1, 2009 8:24:35 AM

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Item Name: Panel w/o Rotor Brake-Ivory

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Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/09 *[Signature]**U 91-07-09*

Picklist Print

July 1, 2009 8:24:34 AM

Page 1

Work Order ID: 48588A

Parent Item: D3821-1KIVRevB

Parent Item Name: Panel w/o Rotor Brake-Ivory

Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	1,029.030	12.8543			



6185 KYDEX .080"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1029.03

1029.03

BB 09/07/08 X.1

Date: Monday, 15/06/2009 4:19:31 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PANEL-W/O ROTOR BRAKE, IVORY
Job Number :	48588A		
Estimate Number :	13583		
P.O. Number :		Part Number :	D38211KIV
This Issue :	15/06/2009	Drawing Number :	D38211
Prsht Rev. :	NC	Project Number :	
First Issue :	//	Drawing Revision :	AB
Previous Run :	47669A	Material :	MKYD6185S080P362015
Written By :		Due Date :	22/06/2009
Checked & Approved By :		Qty:	8 Um: EACH
Comment :	Est. A New Issue 08/09/17 DL Est. B Add Colour Code 09/06/02 DL		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	MKYD6185S080P362015	6185 KYDEX .080"
-----	---------------------	------------------



Comment: Qty.: 12.7969 sf(s)/Unit Total : 38.3906 sf(s)
 6185 Kydex .080" Ivory

M109703

BB 09/07/01

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------

**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/07/01

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------

**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/07/01

4.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3821-1 and folio FTA 023 using tool DT 9053

Dwg. Rev. _____

Folio Rev. _____

BB 09/07/01 (X1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 15/06/2009 4:19:31 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-W/O ROTOR BRAKE, IVORY

Job Number: 48588A

Part Number: D38211KIV

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/07/08 (X1)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Wh 09/07/08 (X1)

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/07/08 (X1)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/07/08 (X1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/07/08 (X1)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 48588A
Description:		Part Number: D3821-KIV
Inspection Dwg:	Rev: A B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/07/08

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00		1.125	✓			
.75		.75	✓			
.63		.70	✓			
.25	Min	.30	✓			
.375	Min	.385	✓			

Measured by: BB

Date: 07/07/08

Audited by: S

Date: 07/07/08

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

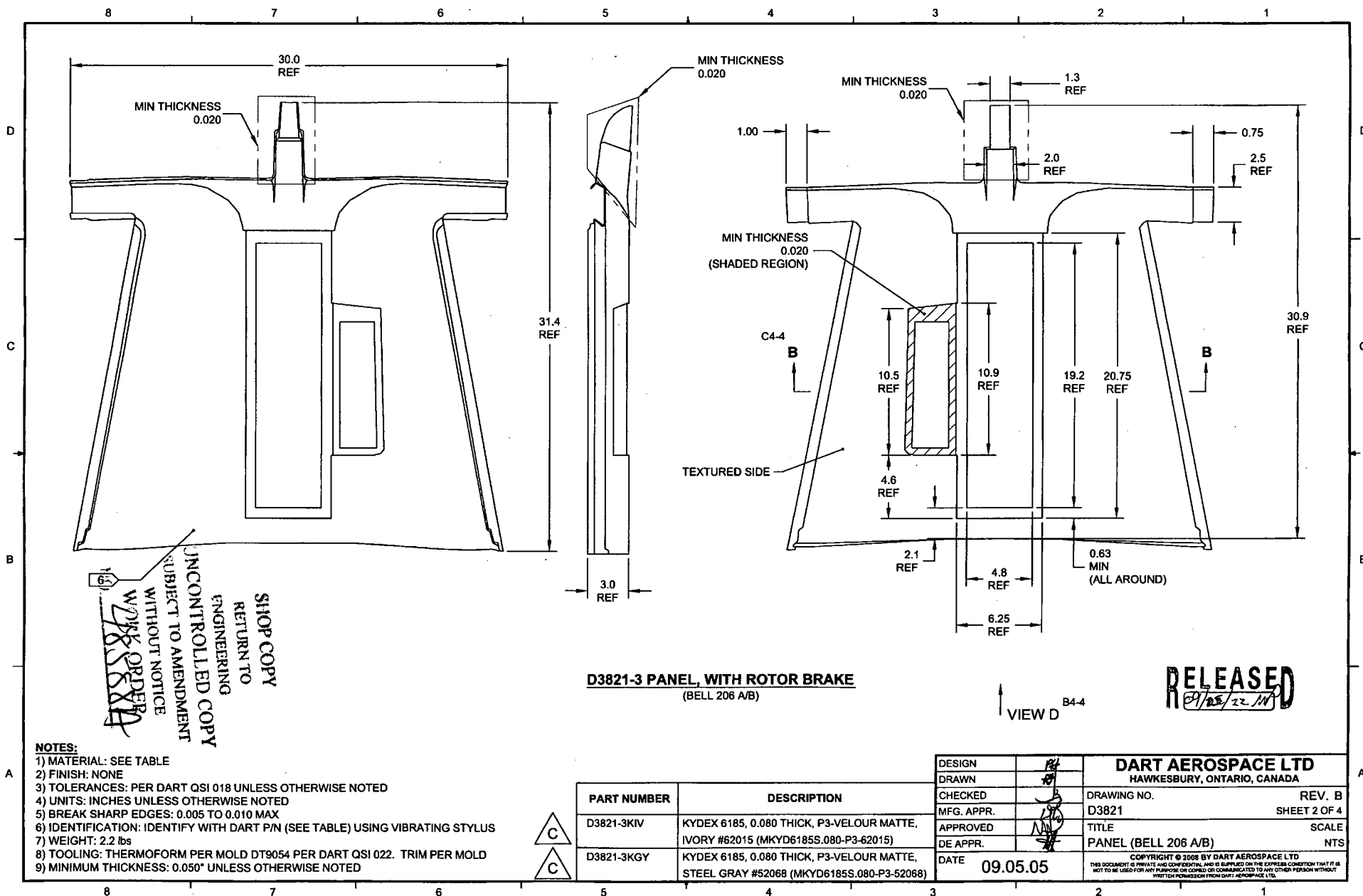
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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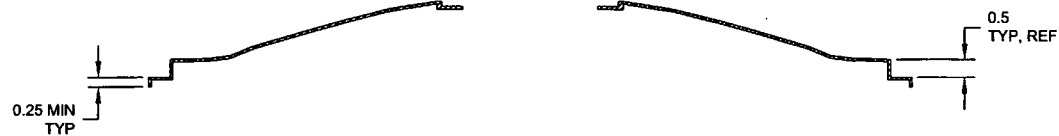
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

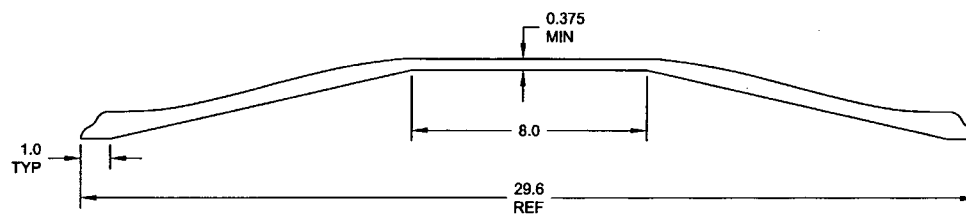
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A C4-1



VIEW C A2-1

RELEASED
07/25/22

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 485887

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3821	SHEET 3 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		PANEL (BELL 206 A/B)	NTS
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DATE	09.05.05		

Dart Aerospace Ltd

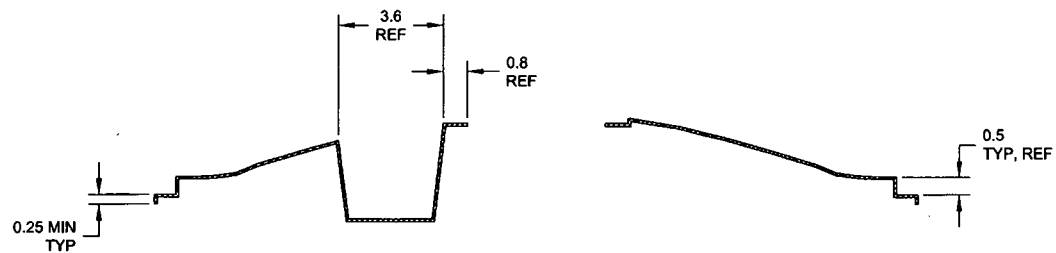
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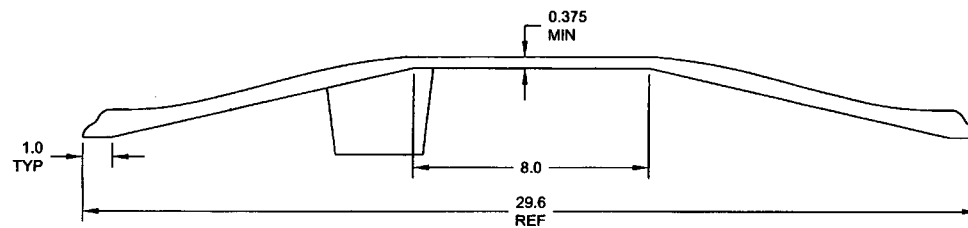
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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SECTION B-B C4-2



VIEW D C4-2

RELEASED
09/05/22 JAV

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NO. *[Signature]*

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3821	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PANEL (BELL 206 A/B)	NTS
DATE	09.05.05	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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